

Work Order ID 104998

104998

Page 1

July-23-13 12:58:35 PM

Item ID: D4419-3 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Aft Support Plate
 Start Date: 7/23/13 Start Qty: 12.00 ***12*** Cust Item ID:
 Required Date: 7/23/13 Req'd Qty: 12.00 ***12*** Customer:
 Reference:

Approvals: Process Plan: MLS Date: 13-07-25 Tooling: _____ Date: _____
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____
 Run Start ***NR1***
 Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4419	A								

100

0.00

100

Waterjet

FLOW CNC Waterjet

Memo

1-Cut as per Dwg

Dwg Rev: A

Prog Rev: A

2-Deburr if necessary

0.00

12 0 Jm13-10-06

110

QC2-Inspect parts off machine FAI/FAIB

0.00

110

QC

Quality Control

Memo

0.00

12 0 Jm13-10-06

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

QA Closed: _____ Date: _____

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube <input type="checkbox"/></td> <td>Crosstube <input type="checkbox"/></td> <td>Water Jet <input type="checkbox"/></td> <td>Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	
Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>															
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Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>																

Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data									
Equip/Tooling									
Operator									
Material									
Setup									
Other									
Process									
Supplier									
Training									
Unapproved									

FAULT CATEGORY

Landing Gear	General	Other
<input type="checkbox"/> Bending	<input type="checkbox"/> Bend	<input type="checkbox"/> Grain
<input type="checkbox"/> Centre Not Concentric to O/S	<input type="checkbox"/> BOM/Route	<input type="checkbox"/> Hardware
<input type="checkbox"/> Cracks	<input type="checkbox"/> Broken/Damaged	<input type="checkbox"/> Inspection Incomplete
<input type="checkbox"/> Crushed/Crimped	<input type="checkbox"/> Burrs	<input type="checkbox"/> Instructions Incomplete/Unclear
<input type="checkbox"/> Cuffs	<input type="checkbox"/> Contamination	<input type="checkbox"/> Maintenance
<input type="checkbox"/> Heat Treat	<input type="checkbox"/> Countersink	<input type="checkbox"/> Mislabelled
<input type="checkbox"/> Inspection Strip in Tube	<input type="checkbox"/> Cut Too Short	<input type="checkbox"/> Misread
<input type="checkbox"/> Ripples in Bend	<input type="checkbox"/> Drill Holes	<input type="checkbox"/> Offset
<input type="checkbox"/> Torque Waves in Extrusion	<input type="checkbox"/> Drawing	<input type="checkbox"/> Out of Calibration
<input type="checkbox"/> Turning Sequence	<input type="checkbox"/> Finish	<input type="checkbox"/> Out of Sequence
<input type="checkbox"/> Wave/Twist in Tube	<input type="checkbox"/> Folio	<input type="checkbox"/> Outside Dimensions
		<input type="checkbox"/> Ovalized
		<input type="checkbox"/> Over/Under tolerance
		<input type="checkbox"/> Part Incorrect
		<input type="checkbox"/> Part Lost/Missing
		<input type="checkbox"/> Part Moved
		<input type="checkbox"/> Positioned Wrong
		<input type="checkbox"/> Power Loss/Surge
		<input type="checkbox"/> Pressure/Forced
		<input type="checkbox"/> Temperature/Cure
		<input type="checkbox"/> Weld
		<input type="checkbox"/> Wrong Stock Pulled
		<input type="checkbox"/> Other

104998

July-23-13 12:58:35 PM

N900040100

Setup Start *NS1*

Stop *NS2*

12

Cust Item ID:

12

Customer:

Reference:

Run Start *NR1*

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Stop *NR2*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

**Insp.
Stamp**

DAS

120

27
9-89

0.00 B p. 7

Memo

Quality Control

Identify as per dwg & Stock Location: S1108 0.00

0.00

130

0.00

Packaging

Memo

Packaging

0.00

0.00

140

QC21- Final Inspection - Work Order Release

140

0.00

QC

Memo

Quality Control

DAS
26
9-8

12x

13-10-8

Am 13/10/08

MF
13-10-08

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

QA Closed: _____ Date: _____

Work Order: _____ Part No. _____ NCR No. _____				DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>		AGAINST DEPARTMENT/PROCESS <div style="display: flex; justify-content: space-between;"> <div> Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/> </div> <div> Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/> </div> <div> Water Jet <input type="checkbox"/> Prod. Eng. Coord. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/> </div> <div> Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/> </div> </div>					
Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector		
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Process <input type="checkbox"/>											
Supplier <input type="checkbox"/>											
Training <input type="checkbox"/>											
Unapproved <input type="checkbox"/>											
FAULT CATEGORY											
Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric to O/S <input type="checkbox"/> Cracks <input type="checkbox"/> Crushed/Crimped <input type="checkbox"/> Cuffs <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Ripples in Bend <input type="checkbox"/> Torque Waves in Extrusion <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube			General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damaged <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drill Holes <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Folio			<input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Maintenance <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Offset <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Outside Dimensions			<input type="checkbox"/> Ovalized <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other		

Picklist Print

July-23-13 12:58:35 PM

Page 1 / 1

Work Order ID: 104998
Parent Item: D4419-3
Parent Item Name: Aft Support Plate

Start Date: 7/23/13 Required Date: 7/23/13
Start Qty: 12.00 Required Qty: 12.00

Comments: IPP REV:A NEW ISSUE 11-07-11 JLM VERIFIED BY:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

M304S11GA		Purchased	No				sf	288.3533					
304/316 0.125 Sheet													

4365474
5

Jm B-10-06

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
MAT020	288.3532632	
122521	19.1432632	
124445	95.2	
M126075	174.01	

126075

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

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Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube <input type="checkbox"/></td> <td>Crosstube <input type="checkbox"/></td> <td>Water Jet <input type="checkbox"/></td> <td>Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	
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Equip/Tooling									
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Supplier									
Training									
Unapproved									

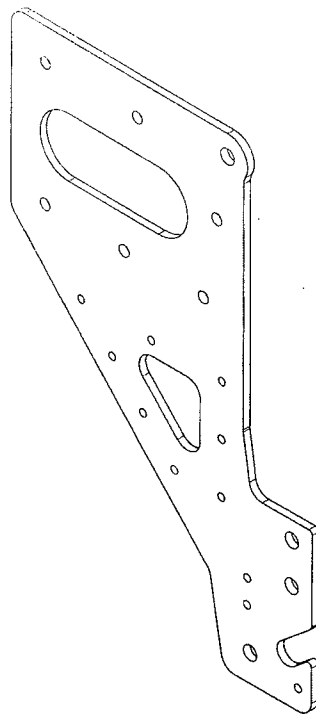
FAULT CATEGORY

Landing Gear	General	Other
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<input type="checkbox"/> Centre Not Concentric to O/S	<input type="checkbox"/> BOM/Route	<input type="checkbox"/> Hardware
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<input type="checkbox"/> Heat Treat	<input type="checkbox"/> Countersink	<input type="checkbox"/> Mislabeled
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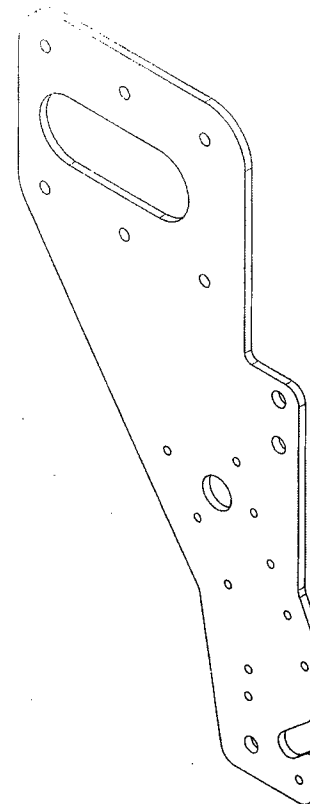
DART AEROSPACE LTD		Work Order:	104998
Description: Aft Support Plate		Part Number:	D4419-3
Inspection Dwg: D4419 Rev: A		Page 1 of 2	

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.129	+0.005/-0.001	0.130"	-		✓	Known
Ø0.191	+0.005/-0.001	0.193"	-		✓	
Ø0.250	+0.005/-0.001	0.250"	-		✓	
Ø0.53	+0.008/-0.001	0.531"	-		✓	
5.55	+/-0.030	5.55"	-		✓	
5.27	+/-0.030	5.274"	-		✓	
4.25	+/-0.030	4.259"	-		✓	
2.80	+/-0.030	2.801"	-		✓	
0.40	+/-0.030	0.406"	-		✓	
3.83	+/-0.030	3.833"	-		✓	
5.56	+/-0.030	5.56"	-		✓	
6.26	+/-0.030	6.263"	-		✓	
7.14	+/-0.030	7.14"	-		✓	
7.73	+/-0.030	7.73"	-		✓	
0.31	+/-0.030	0.317"	-		✓	
0.38	+/-0.030	0.390"	-		✓	
0.750	+/-0.010	0.754"	-		✓	
1.53	+/-0.030	1.533"	-		✓	
0.390	+/-0.010	0.392"	-		✓	
0.450	+/-0.010	0.457"	-		✓	
1.67	+/-0.030	1.680"	-		✓	
10.55	+/-0.030	10.55"	-		✓	Producer
8.00	+/-0.030	8.00"	-		✓	
6.02	+/-0.030	6.02"	-		✓	
1.10	+/-0.030	1.10"	-		✓	
1.20	+/-0.030	1.201"	-		✓	
0.50	+/-0.030	0.507"	-		✓	
1.500	+/-0.010	1.505"	-		✓	
0.60	+/-0.030	0.60"	-		✓	
2.300	+/-0.010	2.307"	-		✓	
0.63	+/-0.030	0.63"	-		✓	
0.991	+/-0.010	0.997"	-		✓	
0.440	+/-0.010	0.443"	-		✓	



D4419-1 FWD SUPPORT PLATE



D4419-3 AFT SUPPORT PLATE

104998 MJS
13-07-25

RELEASED
2011-07-28
WV

NOTES:

- 1) MATERIAL: 303/304/316 STAINLESS STEEL SHEET ANNEALED 2B, 0.125 THK
PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME SA240
REF DART SPEC M304S11GA OR M303S11GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT -1: 0.88 lbs
-3: 1.10 lbs

A	NEW ISSUE	DESCRIPTION	AJS	11.07.06
REV.			BY	DATE
DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
DRAWN	AJS			
CHECKED	97	DRAWING NO. D4419	REV. A	SHEET 1 OF 3
MFG. APPR.	EE	TITLE BASKET SUPPORT PLATES	SCALE	NTS
APPROVED	MP	COPYRIGHT © 2011 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS UNDERSTANDING THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD		
DE APPR.	TH			
DATE	11.07.06			

Technical drawing of a mechanical part, likely a bracket or plate, showing dimensions and references. The drawing includes the following details:

- Dimensions:**
 - Overall width: 5.70
 - Overall height: 8.78
 - Top horizontal segments: 4.40, 1.30, 1.15
 - Left vertical segments: 0.55, 1.20, 3.25, 1.10, 4.10, 7.32
 - Right vertical segments: 4.35, 4.71, 5.71
 - Internal horizontal segments: 2.80, 1.15, 0.80, 1.65, 1.91
 - Internal vertical segments: 1.20, 0.840, 0.450
 - Bottom horizontal segments: 1.65, 1.91
 - Diagonal segment: 0.390
- References and Notes:**
 - SEE DETAIL A C3-2
 - R0.55 REF
 - 43° REF
 - SEE DETAIL B A3-2
 - 80° REF
 - R0.25 10 PL
 - R0.06 3 PL
 - SEE DETAIL C A1-2
- Geometric Features:**
 - Top horizontal edge with a central slot.
 - Left vertical edge with a central slot.
 - Right vertical edge with a central slot.
 - Bottom horizontal edge with a central slot.
 - Diagonal edge on the right side.
 - Various circular holes and slots.

Technical drawing of a rectangular plate with a central oval hole and six circular holes. The drawing includes the following dimensions and specifications:

- Overall width: 3.900
- Overall height: 2.300
- Top edge dimensions: 0.25, 1.750, 0.303, R0.38
- Left edge dimension: 0.50
- Right edge dimension: 1.500
- Central oval hole dimensions: 1.500 (width), 1.500 (height)
- Hole diameters: $\varnothing 0.257$ (top right), $\varnothing 0.191$ (bottom right), 6 PL (bottom right)

Technical drawing of a mechanical part showing dimensions and hole specifications:

- Hole 1: $\varnothing 0.129$, 2 PL.
- Hole 2: $\varnothing 0.250$, 3 PL.
- Dimensions: 0.38, 0.34, 0.750, 1.37, 0.440, 0.125, 0.760, 0.375, 0.063, 0.250, 0.900.

1.330 1.330

0.40

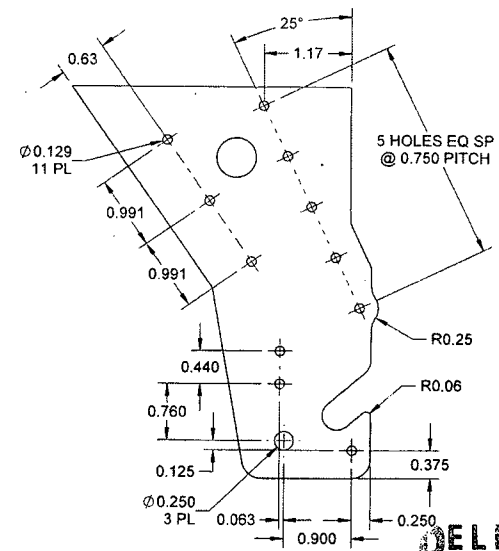
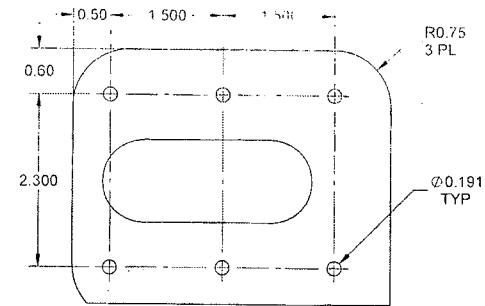
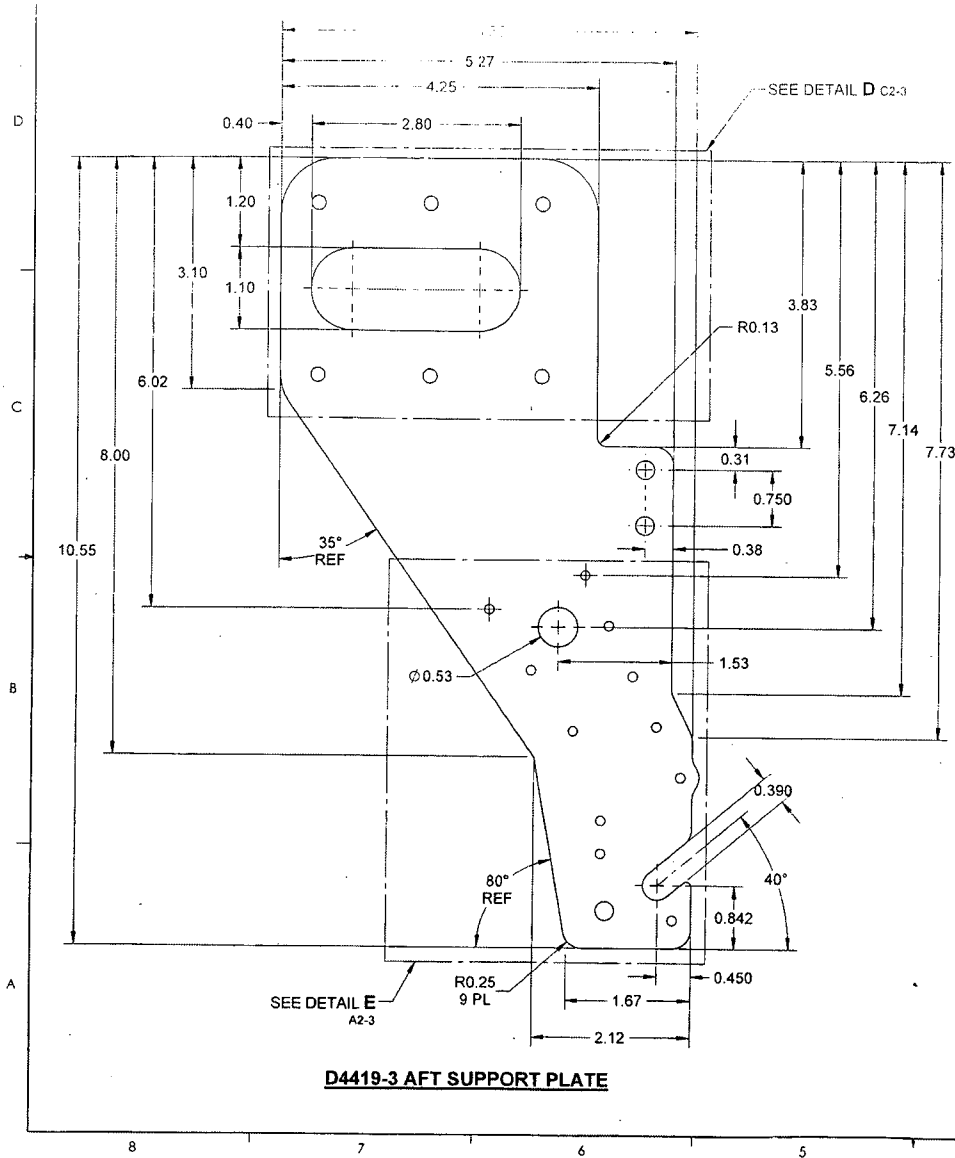
0.950 0.950

4 HOLES EQ SP
@ 0.866 PITCH

$\varnothing 0.129$
TYP

DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D4419 TITLE BASKET SUPPORT PLATES COPYRIGHT © 2011 BY DART AEROSPACE LTD. <small>THIS DOCUMENT IS PRIVATE PROPERTY OF DART AEROSPACE LTD. NO REPRODUCTION, IN ANY FORM OR BY ANY MEANS, IS TO BE USED FOR ANY PURPOSES OR COMMERCIAL USE TO ANY OTHER PERSON OR ENTITY EXCEPT FOR MEMBERSHIP OF DART AEROSPACE LTD.</small>	REV. A	
DRAWN	AJS		SHEET 2 OF 3	
CHECKED	<i>JP</i>			
MFG. APPR.	<i>BE</i>			
APPROVED	<i>AD</i>			SCALE
DE APPR.	<i>TH</i>			NTS
DATE	11.07.06			

104998



DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO. D4419	REV. A
MFG. APPR.	<i>[Signature]</i>	SHEET 3 OF 3	
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	BASKET SUPPORT PLATES	
DATE	11.07.06	NTS	

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RELEASED
2011-11-18